

Work Order ID 85806

85806

Page 1

Item ID: D2857-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hinge Bracket

Start Date: 15/06/2012 Start Qty: 20.00

20

Required Date: 29/06/2012 Req'd Qty: 20.00

20

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/15 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2857	Rev C								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks 4.425"								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FA940 FOLIO REV: <u>AA</u> DWG REV: <u>C</u> 2-Deburr any rough edges								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

PD 12/08/02

20 0

25 12-08-15 (x 20)

25 12-08-15 (x 20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

June-15-12 1:25:31 PM

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

SL 12-08-15

20 20 12-8-16

20X 12/8/16

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

20X ~~Ø~~

M/L
12/08/16

M121841

11:30

320°F

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

20 ~~Ø~~

SL 128-20

180

Identify as per dwg & Stock Location. 019

0.00

180

Packaging

Memo

0.00

Packaging

SL 12/08/20 SL

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 12/08/20
MLJ 12/08/20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-15-12 1:25:35 PM

Page 1

Work Order ID: 85806

85806

Parent Item: D2857-2

D2857-2

Parent Item Name: Hinge Bracket

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C 00.06.22 Removed P/O for powder coatEC
IPP D 06.03.30 Added level 8 EC IPP Rev:E 11.01.06 as
per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	18.7308	0.37	7.789474			

M6061T6B2 000X01 250

6061-T6 Bar 2.00 x 1.25

**

PO

12/08/02

Location

Loc Qty

Loc Code

MAT009

18.39326358

114899

4.15263158

116623

2.15

119136

1.290632

→ 121660

10.8

MAT010

0.3375

121040

0.3375

→ 122321

7.79

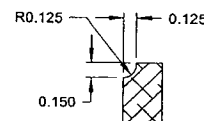
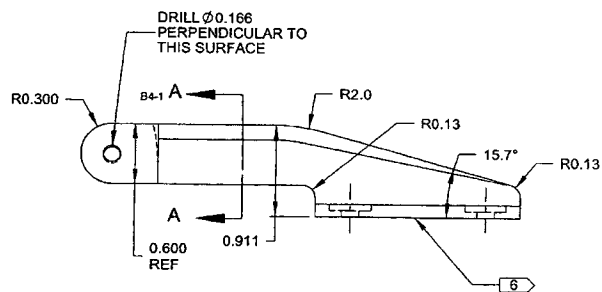
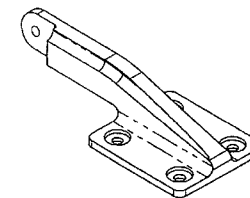
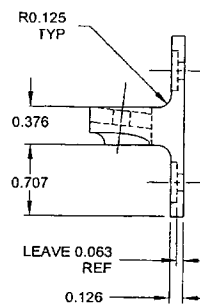
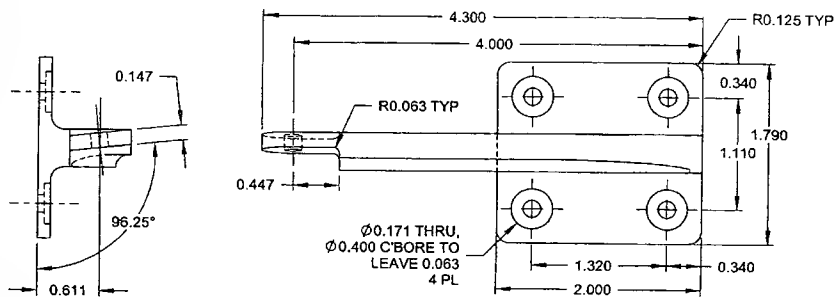
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NOTE: Date & initial all entries



B7-1 SECTION A-A

D2857-1 HINGE BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85806 MLE
12/06/15

RELEASED
R 2010-11-26

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG. IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	06.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KE		
CHECKED	KE	DRAWING NO.	REV. C
MFG. APPR.	KE	D2857	SHEET 1 OF 2
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	HINGE BRACKET	NTS
DATE	10.09.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

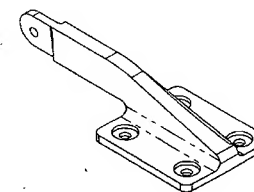
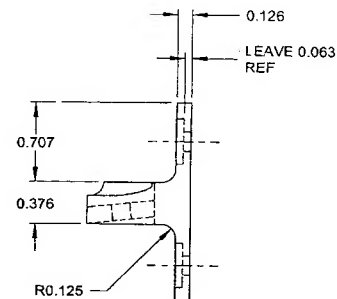
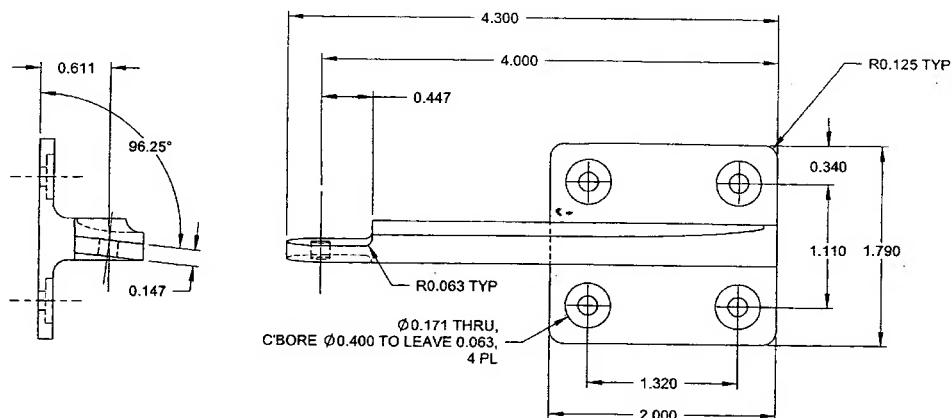
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

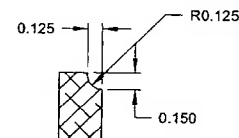
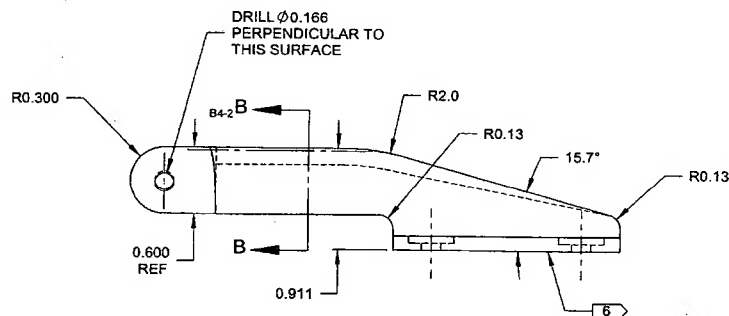
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NOTE: Date & initial all entries



25806



B7-2 SECTION B-B

D2857-2 HINGE BRACKET

NOTES:

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REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-2" PER DART QSI 044 6.1(FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2857	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE BRACKET	NTS
DATE	10.09.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2010-11-26

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	85806
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857	Rev: <i>[Signature]</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300	✓		vern	BT-4
4.000	+/-0.010	4.006	✓		"	
0.340	+/-0.010	.339	✓		"	
1.110	+/-0.005	1.109	✓		"	
1.790	+/-0.010	1.788	✓		"	
1.320	+/-0.005	1.319	✓		"	
2.000	+/-0.010	1.999	✓		"	
0.340	+/-0.010	.340	✓		"	
0.447	+/-0.010	.450	✓		"	
Ø0.171	+0.005/-0.000	.173	✓		"	
0.147	+/-0.010	.147	✓		"	
0.376	+/-0.010	.378	✓		"	
0.126	+/-0.010	.122	✓		"	
0.063	+/-0.010	.062	✓		"	
Ø0.166	+0.005/-0.000	.167	✓		"	
0.911	+/-0.010	.908	✓		"	
0.600	+/-0.010	.695	✓		"	
0.125	+/-0.010	.130	✓		"	
0.150	+/-0.010	.150	✓		"	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 12-08-14	Date: 12-08-14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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